

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH	
Job Number	: 28901				
Estimate Number	: 10268				
P.O. Number	: N/A		Part Number	: D350636014	
This Issue	: 10/11/2006	S.O. No. : N/A	Drawing Number	: D2750 REV D	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A	Type : LANDING GEAR	Drawing Revision	: D	
Previous Run	: 28900		Material	: N/A	
Written By	:		Due Date	: 11/10/2006	Qty: 1 Um: Each
Checked & Approved By	:				
Comment	:	Est Rev: H 02.09.25 Rearranged procedure steps KJ			
		Est Rev: I 05.12.08 Rearranged procedure steps EC			
		Est Rev: J 06.03.30 Per rev. D EC			

Job Number:



1.0	DC	DOCUMENT CONTROL
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Photocopy blue file and type labels per PPP D350-636-014 CHG 002

KJ 06.10.11

2.0	D26003BENT	Extrusion Bent
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Batch

1 D2600-3-Bent

Extrusion (Bent)

Batch
326787 Pm'06-10-24①

3.0	D2744	Fwd Cap
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Cap

Batch: B 25839 BE 06-10-25

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end *Pm 06-10-24*

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750. *pm 06-10-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:48:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill pilot holes for Detail B using DT8330

Pm'06-10-24 ①

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" wearplate holes are on bottom of tube*****

***Make sure that

Pm'06-10-24 ①

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

Pm'06-10-24 ①

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

Pm'06-10-30 ①

8-Countersink Detail A as per dwg D2750.

Pm'06-10-30 ①

9-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

Pm'06-10-24 ①

10-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod

M 10/6/55 BE 06-10-25 ①

11-Grind welds flush as per Dwg D2750

Pm'06-10-30 ①

5.0

QC5/9

WELD INSPECTION



206-10-30



Comment: WELD INSPECTION

206/10/30 ①

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm'06-10-31 ①



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-10-31

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B27967

Pm'06-10-31 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:48:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *B28874*

BE 06-11-01

10.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *B27834*

BE 06-11-01

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: *B27741*

BE 06-11-01

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes "size X" (total of 4 holes per side) as per dwg D2750

pm'06-10-31

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

pm'06-10-31

3-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

pm'06-10-31

4-Deburr and blow out all chips from inside of tube

pm'06-10-31

5-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

m102107

exp. date: *07-02-01*

pm'06-10-31

6- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

m101655

BE 06-11-01

7-Grind welds flush as per Dwg D2750

BE /mch 06-11-02

W/O:		WORK ORDER CHANGES					
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User: Kim Johnston

Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

BE 06-11-02 (1)

11-Deburr holes

BE 06-11-02 (1)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MA 06/11/06 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06/11/06 (1)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

Y/R 06/11/10 x1

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

A.M. 06/11/15 (1)

17.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch: M102644

A.M. 06/11/15 (1)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

A.M. 06/11/15 (1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

06-11-15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: B28123

21.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27239

22.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B26206

23.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B28257

24.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B27862

25.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B28319

a.m 06/11/16 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:48:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B29017

27.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B28276

28.0

AN835A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: _____

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M102552

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M19522

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M10254

32.0

AN6C44A

BOLT

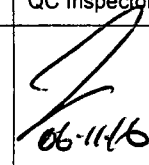


Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 3x M101936 ix M102697

am 06/11/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-16	280	Remove bolt AN8-354. No longer used on digor perm. change					 06-11-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102180

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M101340

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M100186

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M101537

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M100186

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M101418 M101418

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M102535

a.m 06/11/16 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:48:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750 sikaflex batch: M102660

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M101915

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M102660

EXP DATE: 02/07

5-Coat all exposed fasteners with "LPS Procyon" batch: 17168

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/28

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

✓ Batch: B27968

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

✓ Batch: M10186

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: TD Date: 06/12/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 10/11/2006 10:48:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28901

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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45.0	MS21083C8	NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut
✓ Batch: M100184 -

46.0	AN8C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt
✓ Batch: M102473 -

47.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER
✓ Batch: M102515 -

48.0	D34931	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER
✓ Batch: M21835 -

49.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Package as per PPP D350-636-014

NEW 6/11/30 (1)

51.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/12/01

Job Completion



12/06/2001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
06-02-07

DESIGN P/H	DRAWN BY P/H	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28901

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. 0 SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
06.02.07

GENERAL NOTES:

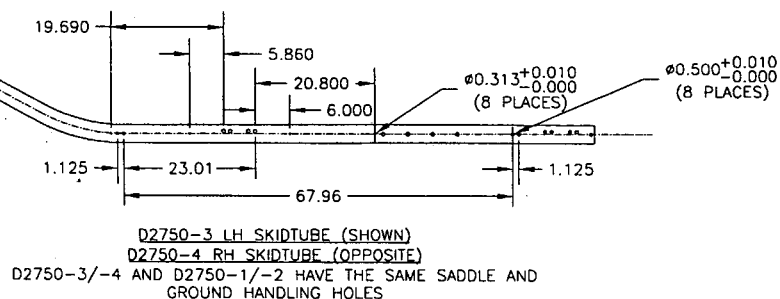
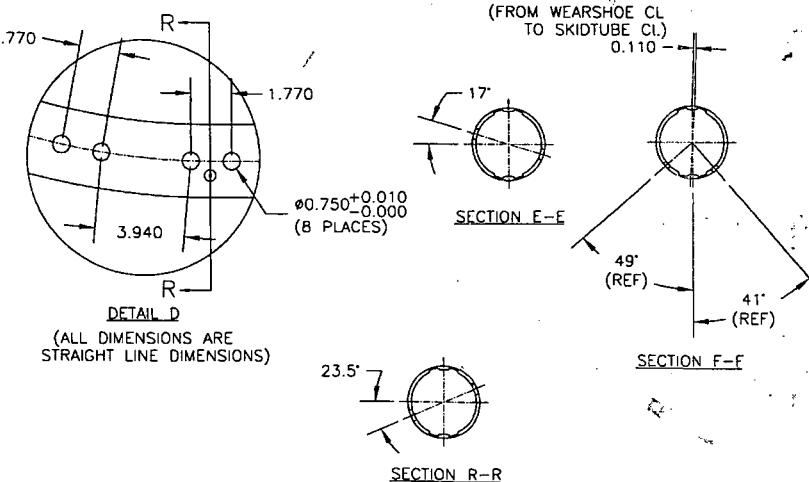
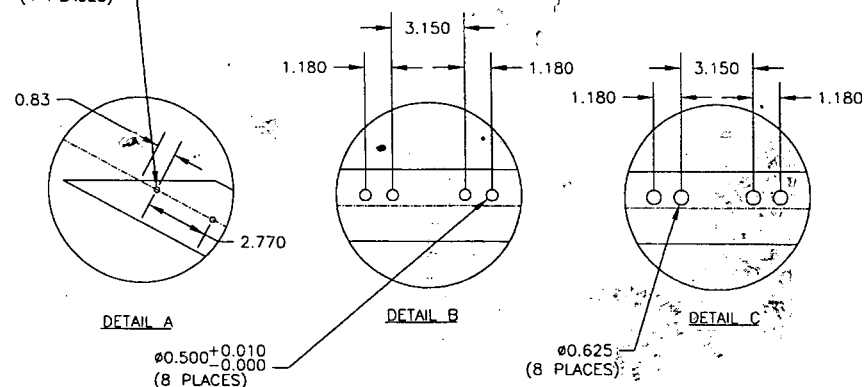
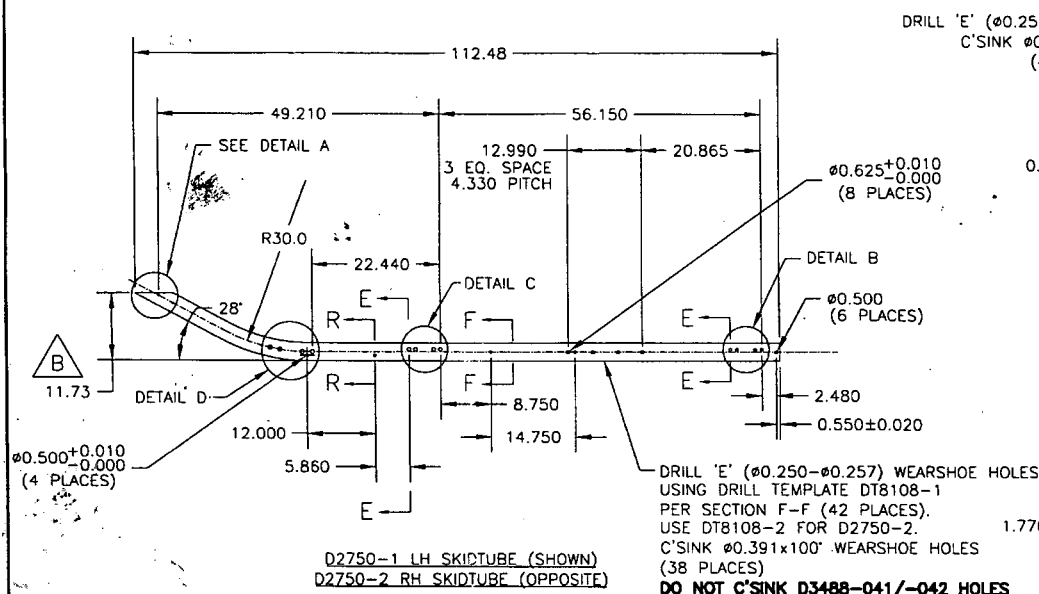
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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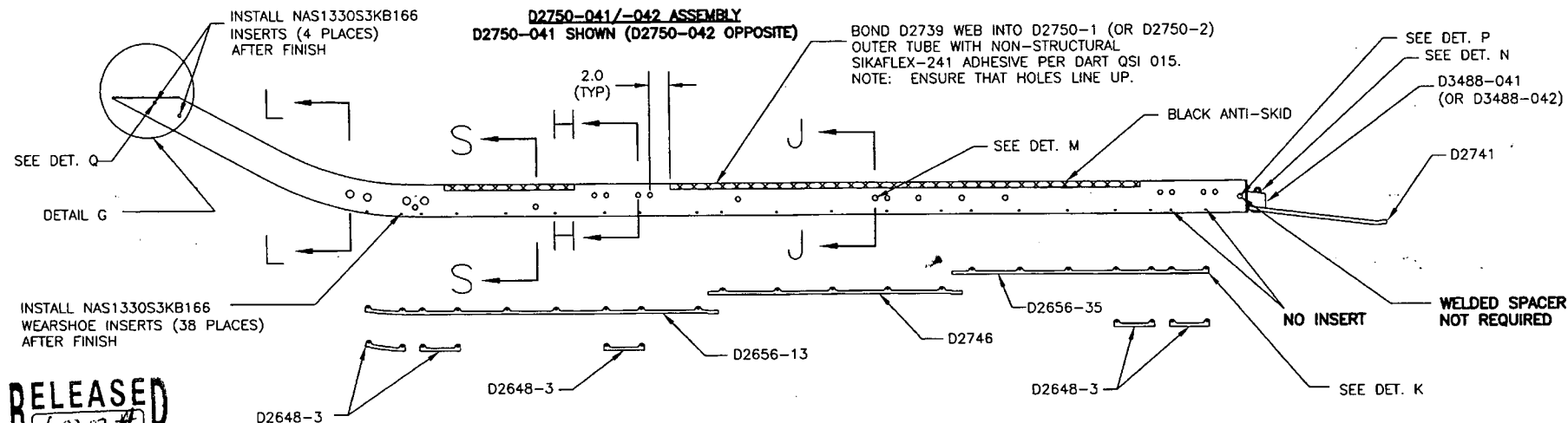
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DATE	06.01.05	DRAWING NO.	D2750
		TITLE	350 SKIDTUBE ASSEMBLY
		REV. D	SHEET 3 OF 5
		SCALE	1:20

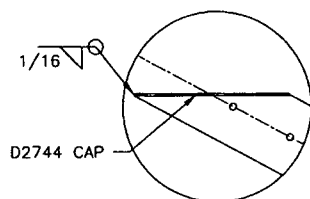
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D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



DETAIL G

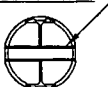


SECTION H-H



(TYP)

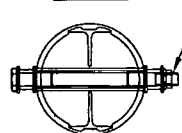
SECTION J-J



WELDING INSTRUCTIONS

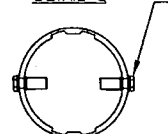
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M

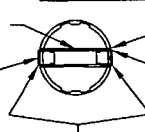


NOTE: INSTALL WASHER BETWEEN
SKIDTUBE AND BUSHING

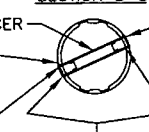
DETAIL Q



SECTION L-L



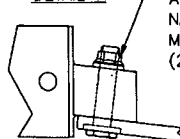
SECTION S-S



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL N



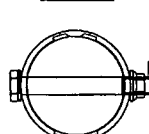
DETAIL K



USE AN3C7A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD
(4 PLACES)

AN3C5A BOLT (1)
AN960J010L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)

DETAIL P



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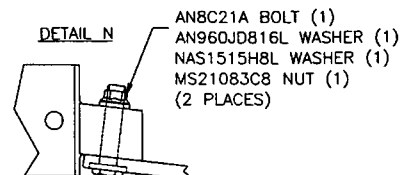
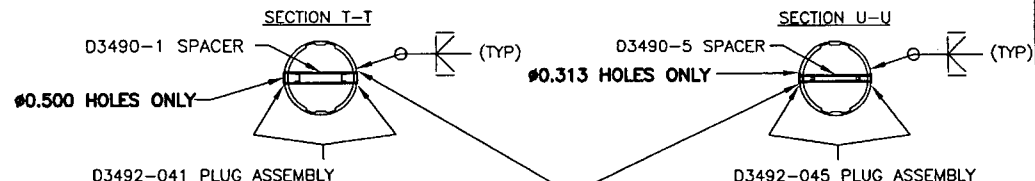
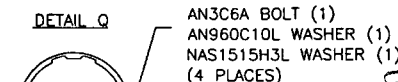
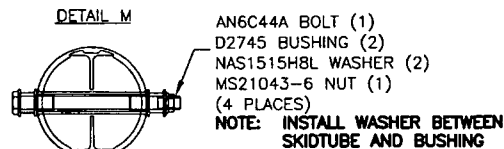
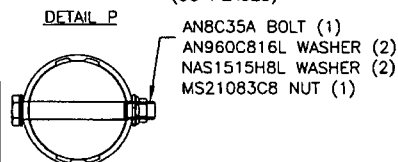
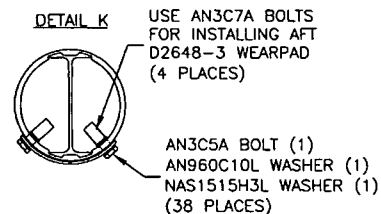
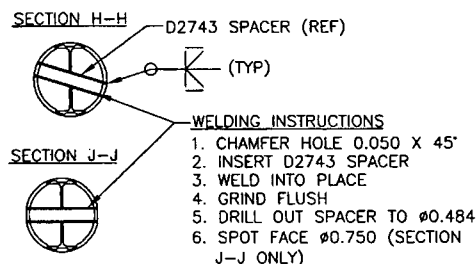
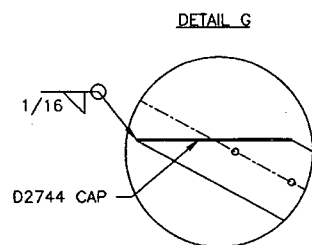
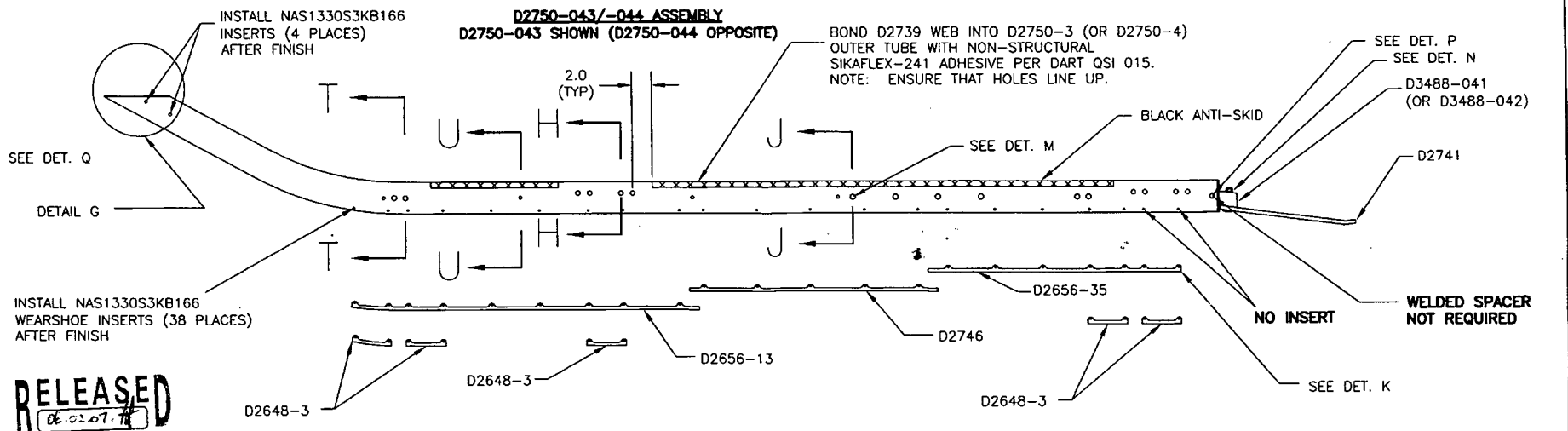
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- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A330636 011 / B29000

TEST WELDS REQUIRED

BASE METAL	<u>Alum</u>	WELDING PROCESS	<u>Tig</u>
Penetration	Complete <input type="checkbox"/> Partial <input checked="" type="checkbox"/>	Single Weld <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/>	
Current	AC <input checked="" type="checkbox"/> DC <input type="checkbox"/>	Backing	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>
	Position	Vertical	Down <input type="checkbox"/> Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/> 3G <input type="checkbox"/> 4G <input type="checkbox"/>		
Tube Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/> 5G <input type="checkbox"/> 6G <input type="checkbox"/>		
Sheet Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/> 3F <input type="checkbox"/> 4F <input type="checkbox"/>		
Tube Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/> 4F <input type="checkbox"/> 5F <input type="checkbox"/>		
Crossbolt Spacer	Welded into		Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/30 Qualifier David Swad